

Amendments to the Claims

This listing of claims will replace all prior listings of claims in the application.

In the claims:

1. (Original) A method for the production of a drilling tool, which can be fitted with a shaft for clamping in a machine tool and with a drill tip (20) provided with cutting edges, by using a tubular blank (22), the tubular blank having a forming part (26) and a clamping part (16) which is arranged at the end of the forming part (26), is integrally connected to the latter and the tubular wall thickness of which is greater than in the region of the forming part (26), the forming part (26) being formed in a non-cutting manner while thereby forming chip grooves (12) and coolant channels (27).

2. (Original) The method for the production of a drilling tool as claimed in claim 1, the outside tube diameter of the tubular blank being greater in the region of the clamping part (16) than in the region of the forming part (26).

3. (Currently Amended) The method for the production of a drilling tool as claimed in claim 1 ~~or 2~~, the inside tube diameter of the tubular blank being equal in the region of the clamping part (16) and the forming part (26).

4. (Currently Amended) The method for the production of a drilling tool as claimed in claim 1 ~~or 2~~, the inside tube diameter of the tubular blank (22) being smaller or greater in the region of the clamping part (16) than in the region of the forming part (26).

5. (Currently Amended) The method for the production of

a drilling tool as claimed in ~~one of claims 1 to 4~~ Claim 1, a preferably planar clamping area (17) being arranged by a metal-cutting or non-cutting process on the outer side of the clamping part (16) of the tubular blank.

6. (Original) The method for the production of a drilling tool as claimed in claim 5, the inside tube diameter of the tubular blank (22) being constant over the length of the clamping part (16).

7. (Original) The method for the production of a drilling tool as claimed in claim 5, the inside tube diameter of the tubular blank (22) varying over the length of the clamping part (16) and being smaller in the region of the clamping area (17) than outside the clamping area (17).

8. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 5 to 7~~ Claim 5, the clamping area (17) running parallel to the tube axis of the tubular blank (22).

9. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 5 to 7~~ Claim 5, the clamping area (17) being aligned obliquely with respect to the tube axis of the tubular blank.

10. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 9~~ Claim 1, the tubular blank (22) having a central channel (24), which has an oval or elliptical outline at least over the length of the clamping part (16).

11. (Original) The method for the production of a drilling tool as claimed in claim 10, the clamping area (17) being arranged in the region of the smaller inside tube diameter of the clamping part (16).

12. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 11~~ Claim 1, the tubular blank (22) having a central channel which, with a constant outside tube diameter, conically diverges at least over part of the length of the forming part (26) toward the free end.

13. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 12~~ Claim 1, a transitional portion (32) running conically on the outside between the clamping part (16) and the forming part (26) of the tubular blank.

14. (Original) The method for the production of a drilling tool as claimed in claim 13, the transitional portion (32) running conically on the inside between the clamping part (16) and the forming part (26) in the same direction as on the outer side.

15. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 14~~ Claim 1, a step-shaped transitional portion (32) being arranged between the clamping part (16) and the forming part (26) of the tubular blank (22).

16. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 13 to 15~~ Claim 13, the transitional portion (32) being formed and dimensioned in such a way that at least one bit seat for receiving a cutting bit can be formed in it there.

17. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 16~~ Claim 1, the tubular blank consisting of a case hardening steel with a phase transition point of from 480 to 650°C.

18. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 17~~ Claim 1, the tubular blank (22) consisting of a case hardening steel with a chromium content of less than 2%, preferably of a 16MnCr5 steel.

19. (Currently Amended) The method for the production of a drilling tool as claimed in claim 17 ~~or 18~~, the tubular blank (22) being hardened, preferably carburized or nitrided, at least on its outer surface, after the forming operation.

20. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 19~~ Claim 1, the forming part (26) being formed by the swaging method.

21. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 20~~ Claim 1, the coolant channels (27) being formed from the central channel of the clamping part (16) steplessly and seamlessly into the forming part (26).

22. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 21~~ Claim 1, a clamping shaft for clamping into a machine tool being clamped or shrink-fitted on in the region of the clamping part (16).

23. (Currently Amended) The method for the production of a drilling tool as claimed in ~~one of claims 1 to 22~~ Claim 1, an inflow chamber (34) which widens with respect to the inside tube diameter of the clamping part (16) and communicates with the coolant channels (27) of the forming part (26) being formed into a transitional portion (32) of the tubular blank (22) that adjoins the clamping part (16) in the direction of the forming part (26) having a smaller tubular wall thickness.

24. (Currently Amended) A method for the production of a drilling tool as claimed in ~~one of claims 1 to 23~~ Claim 1, a piece of tube with a constant inside and outside diameter being used to form the tubular blank, which is subjected to a metal-cutting operation, preferably drilled or turned on a lathe, on its inner and/or outer surface, while thereby forming the forming part (26) that has a thinner wall than the clamping part (16).

25. (Currently Amended) A method for the production of a drilling tool as claimed in ~~one of claims 1 to 23~~ Claim 1, a piece of tube with a constant inside and outside diameter being used to form the tubular blank (22), which is formed, preferably swaged, at least partially over a mandrel from the outside while thereby forming the forming part (26) that has a thinner wall than the clamping part (16).